

Work Order ID 84119-2

May-03-12 11:26:25 AM

84119

Page 1

Item ID: D4617-045

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clamp Assembly

Start Date: 03/05/2012 Start Qty: 8-00

8

Cust Item ID:

Required Date: 17/05/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLC

Date: 12/05/03 Tooling:

Run Start

NR1

QC:

Date: SPC (Y/N):

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4617

A

100

Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

110

0.00

110

Small Fab

Memo

0.00

Small Fab

ASSEMBLE AS PER DWG

120

QC5- inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

Sizelockis

(x4)

FF 12-05-15

FF 12-05-15



Work Order ID 84119

May-03-12 11:26:25 AM

84119

Page 2

Item ID: D4617-045
Revision ID:
Item Name: Clamp Assembly

Accept

N900040100

Setup Start *NS1*
Stop *NS2*

Start Date: 03/05/2012 Start Qty: 8.00

8

Required Date: 17/05/2012 Req'd Qty: 8.00

8

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:
QC:

Date:

Tooling:

Date:

Run Start *NR1*
Stop *NR2*

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

Identify as per dwg & Stock Location: *8T 116*

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

8P.
12-5-16.

12/5/17
MK
12-05-17

Picklist Print

May-03-12 11:26:29 AM

Page 1

Work Order ID: 84119

84119

Parent Item: D4617-045

D4617-045

Parent Item Name: Clamp Assembly

Start Date: 03/05/2012

Required Date: 17/05/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 12.04.13 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A

Purchased

No

100

Each

318.0000

3

24

AN4-14A

Bolt

**

⑧ IF 12-05-15

Location

Loc Qty

Loc Code

357

100

121349

100

ST357

218

120187

13

120769

1

121068

17

121243

87

121444

100

20

D4617-5

Manufactured

No

100

Each

0.0000

1

8

D4617-5

Clamp Body

**

8

⑧ IF 12-05-15

D4617-7

Manufactured

No

100

Each

0.0000

1

8

D4617-7

Clamp Half

**

8

⑧ IF 12-05-15

MS21044N4

Purchased

No

100

Each

88.0000

3

24

MS21044N4

Nut

**

⑧ IF 12-05-15

Location

Loc Qty

Loc Code

GA

88

121464

88

24

Picklist Print

Page 2

May-03-12 11:26:29 AM

Work Order ID: 84119

Parent Item: D4617-045

Parent Item Name: Clamp Assembly

84119

D4617-045

Start Date: 03/05/2012

Required Date: 17/05/2012

Start Qty: 8.00

Required Qty: 8.00

MS22034-4

Purchased

No

100

Each

5.0000

1

8

MS22034-4

FOOT

**

⑧ IT 12-05-15

Location

Loc Qty

Loc Code

ST304

17121662

5

116717

1

121559

4

100

Each

910.0000

3

24

**

⑧ IT 12-05-15

NAS1149C0463R

Purchased

No

NAS1149C0463R

Washer

Location

Loc Qty

Loc Code

FP001

1

115358

1

ST297

909

117735

20

119097

889

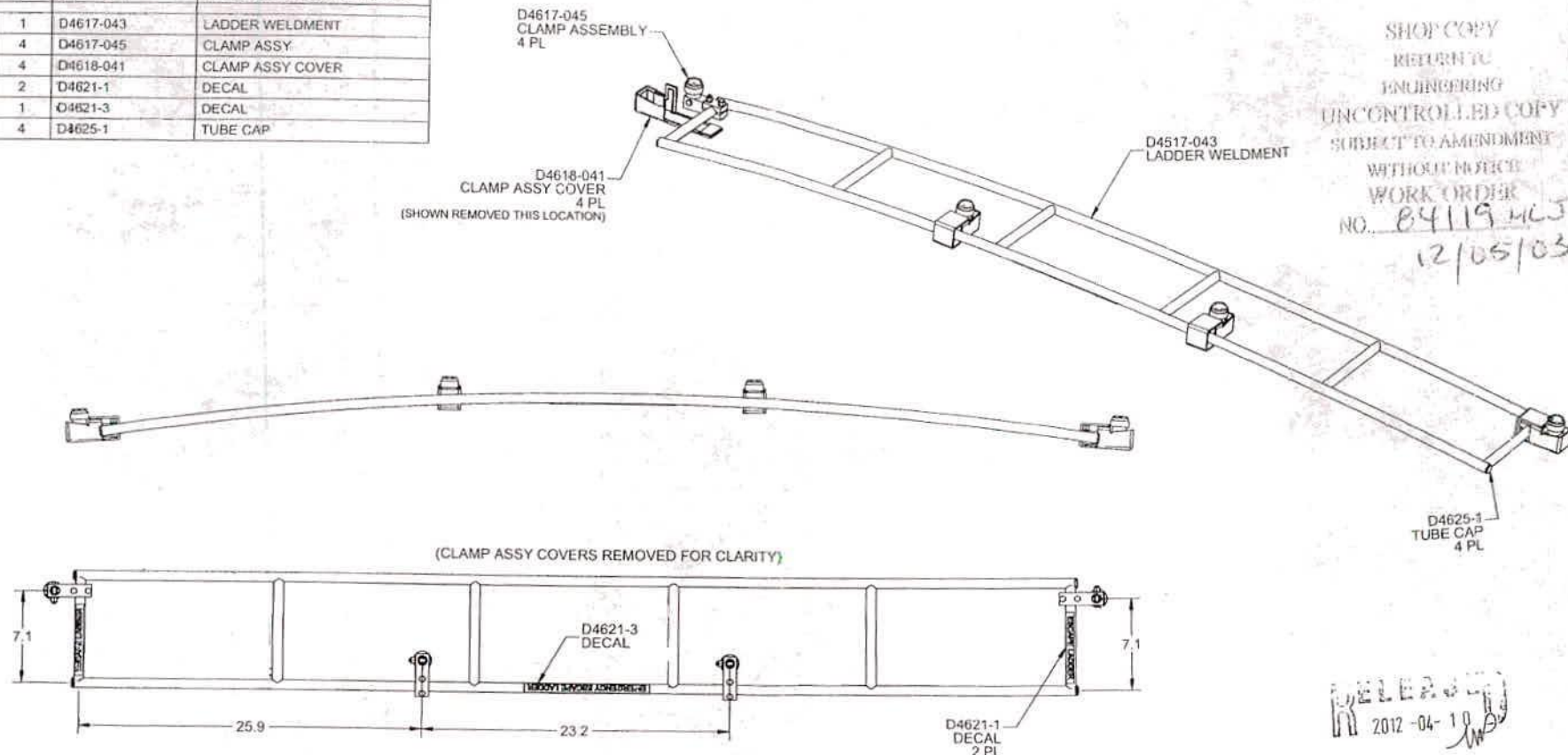
24

May-03-12 11:26:29 AM

Shop Packet Print

Page 2

ITEM	QTY	P/N	DESCRIPTION
	X	D4617-041	EMERGENCY ESCAPE LADDER
1	1	D4617-043	LADDER WELDMENT
2	4	D4617-045	CLAMP ASSY
3	4	D4618-041	CLAMP ASSY COVER
4	2	D4621-1	DECAL
5	1	D4621-3	DECAL
5	4	D4625-1	TUBE CAP



D4617-041 EMERGENCY ESCAPE LADDER

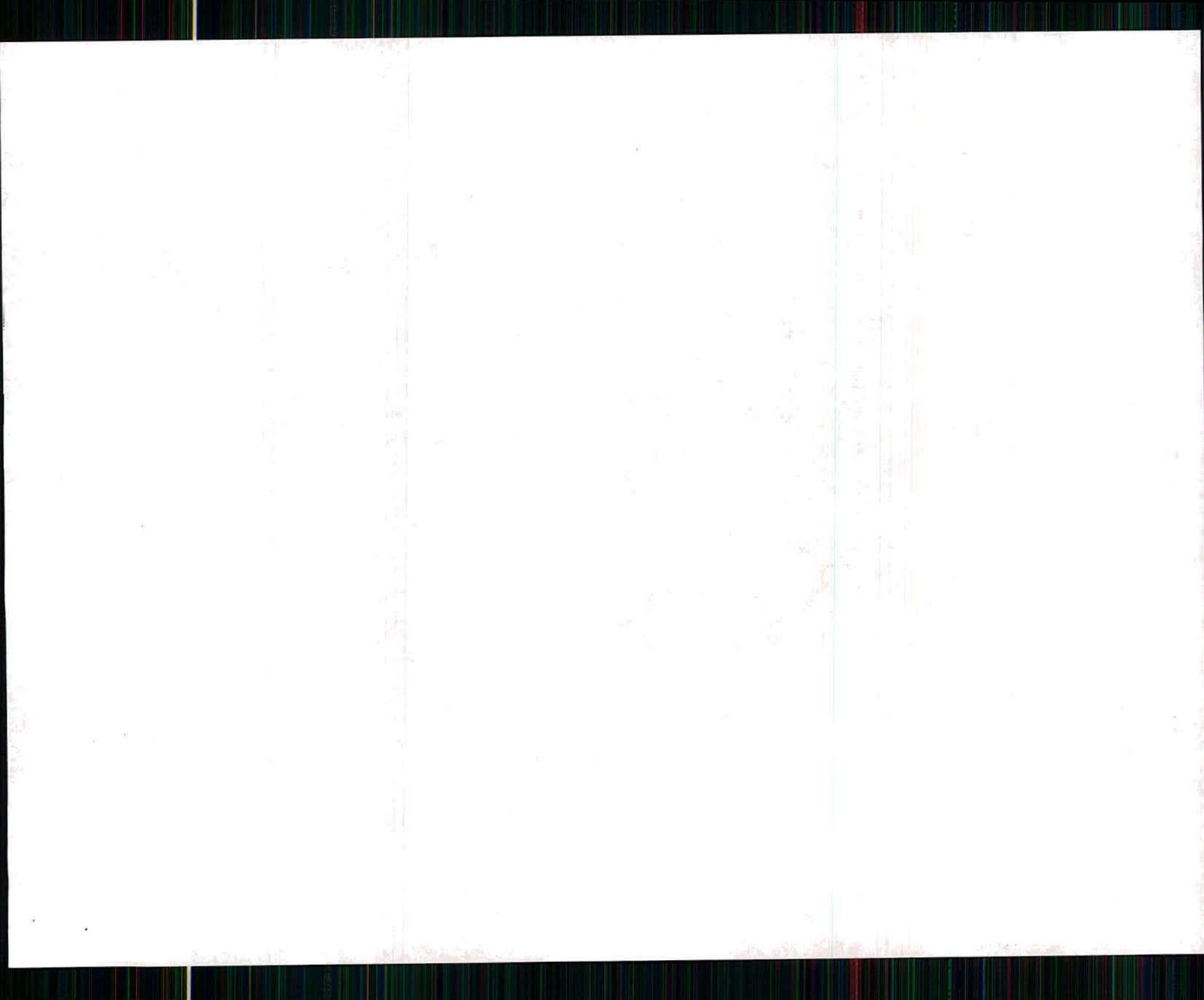
NOTES:

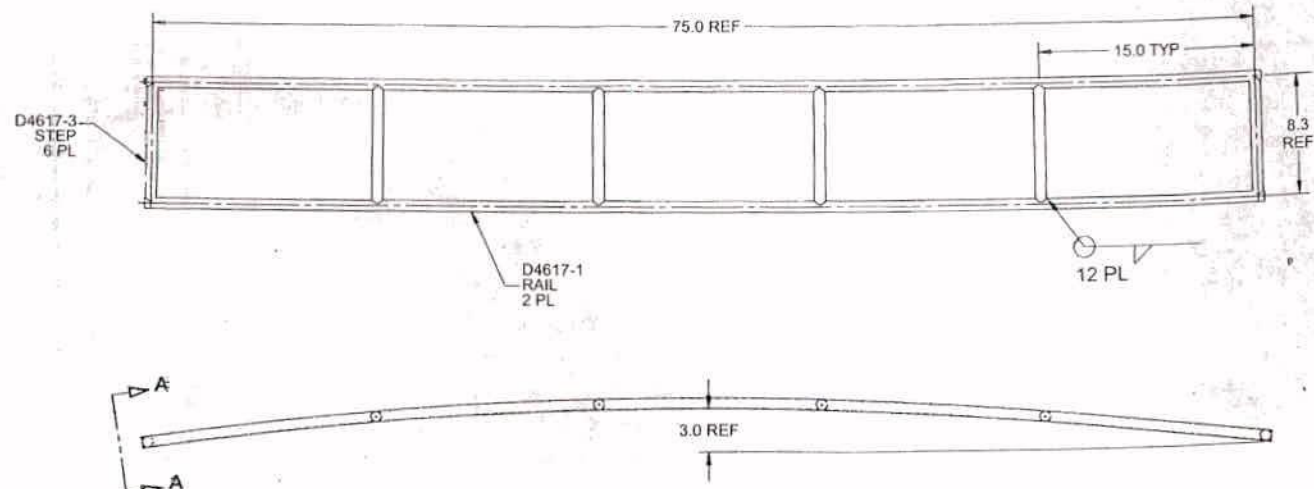
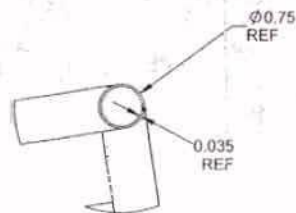
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4617-041" AND BATCH NUMBER PER QSI044 6.6
- 7) WEIGHT: 6.46 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84119 463
12/05/03

RELEASED
2012-04-10

A	NEW ISSUE	RP	12.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	AD	DRAWING NO.	REV. A
MFG. APPR.	AD	D4617	SHEET 1 OF 5
APPROVED	AD	TITLE	SCALE
DE APPR.	AD	EMERGENCY ESCAPE LADDER	NTS
DATE	12.04.02	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND NOT BE LOANED, REPRODUCED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD	





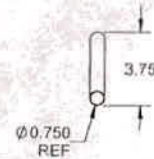
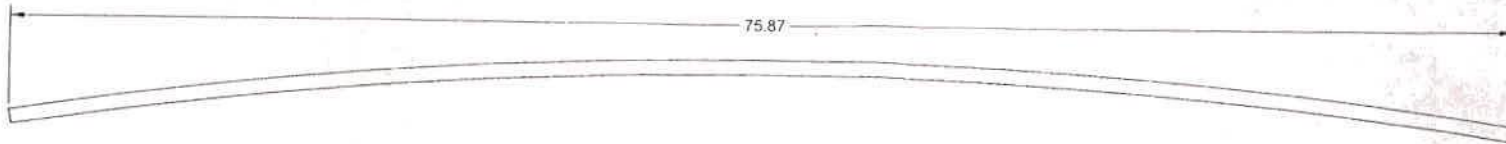
D4617-043 LADDER WELDMENT

RELEASED
2012-04-10

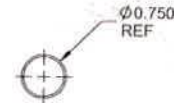
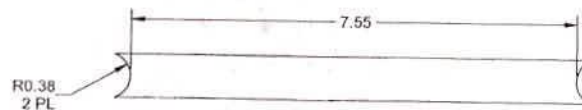
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER DART QSI044 6.6
 - 7) WEIGHT: 4.5 lbs
 - 8) WELDING: PER DART QSI 004

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	AD	DRAWING NO. D4617	REV. A
MFG. APPR.	CE	SHEET 2 OF 5	
APPROVED	WJ	SCALE NTS	
DE APPR.		TITLE EMERGENCY ESCAPE LADDER	
DATE	12.04.02	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE CAPTIONED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

04/19



D4617-1 RAIL



D4617-3 STEP

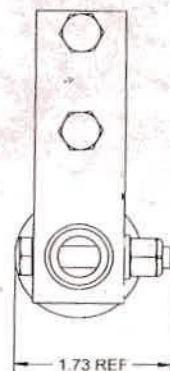
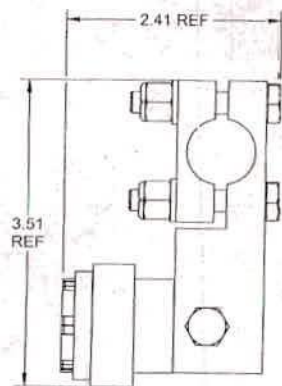
RELEASED
2012-04-18

NOTES:

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T5746
OR AMS6371, 6360, 6361, 6362, 6373, 6374
REF DART SPEC M4130NT0.750W.035
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044 6.6
- 7) WEIGHT: D4617-1 1.7lbs
D4617-3 0.17lbs

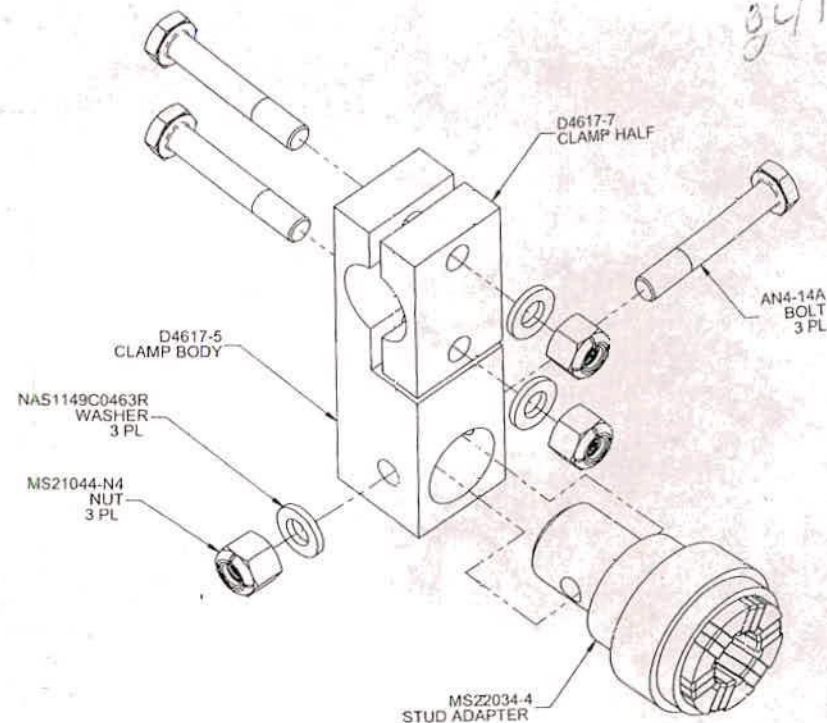
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.		D4617	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		EMERGENCY ESCAPE LADDER	NTS
DATE	12.04.02	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR AIR PURPOSES OR COMMERCE OR COMMUNICATIONS AND OTHER PURPOSES WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM	QTY	P/N	DESCRIPTION
	X	D4617-045	CLAMP ASSEMBLY
1	1	D4617-5	CLAMP BODY
2	1	D4617-7	CLAMP HALF
3	3	AN4-14A	BOLT
4	3	MS21044-N4	NUT
5	1	MS22034-4	STUD ADAPTER
6	3	NAS1149C0463R	WASHER



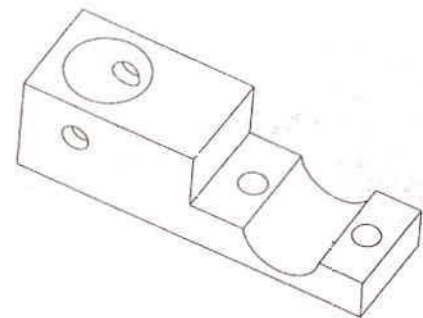
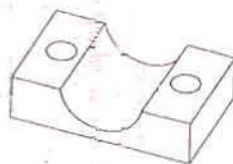
D4617-045 CLAMP ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER DART QSI044 6.6
 - 7) WEIGHT: 0.5 lbs

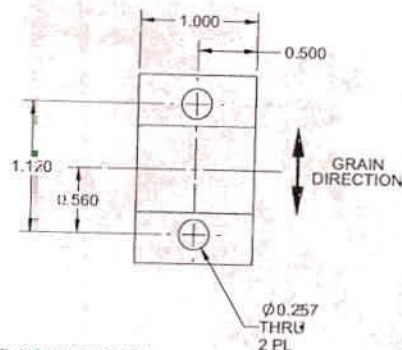
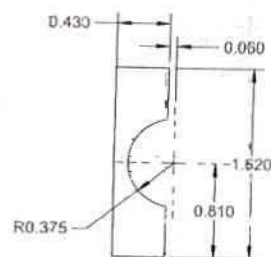


RELEASED
2012-04-18

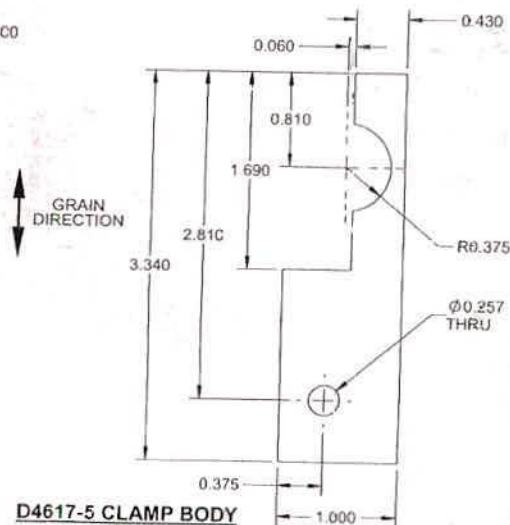
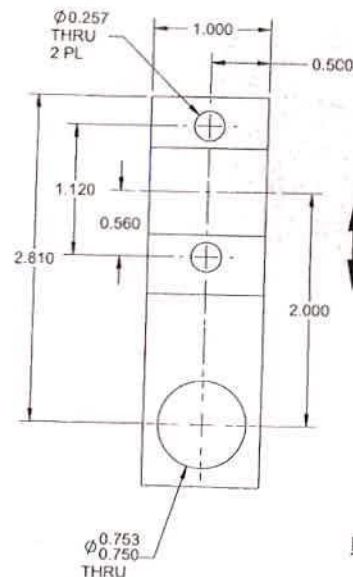
DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	D.O.	DRAWING NO.	REV. A
MFG. APPR.	E.D.	D4617	SHEET 4 OF 5
APPROVED	W.A.	TITLE	SCALE
DE APPR.		EMERGENCY ESCAPE LADDER	NTS
DATE	12.04.02	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES OF THE PROJECT FOR WHICH IT WAS DEVELOPED AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.			



84119



D4617-7 CLAMP HALF



D4617-5 CLAMP BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR
AMS 4117/4128/4115/4116 OR QQ-A-200/8
OR ASTM B211 OR ASTM B221
REF DART SPEC M8061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: D4617-5 0.17 lbs
D4617-7 0.05 lbs
- 8) POSSIBLE SUPPLIER: D4617-5: EAGLE P/N 212-110-06
D4617-7: EAGLE P/N 212-110-07

RELEASED
2012-04-10

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4617	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		EMERGENCY ESCAPE LADDER	NIS
DATE	12.04.02	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OTHER THAN FOR WHICH IT WAS ORIGINALLY DESIGNED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

